

Work Order ID 52785

October 14, 2009 10:41:56 AM



Page 1

Item ID: D412-742-043

Accept



Setup Start



Revision ID: H

Stop



Item Name: Replacement Float Skidtube

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *PP*

Date: *09-10-14*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	Rev H								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

If D412-742-043 is a W/O on it's own,
Photocopy bluefile and create labels per PPP D412-742-043 CHG004

N/A *[Signature]*

Work Order ID 52785

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Page 2

Item ID: D412-742-043

Accept



Setup Start



Revision ID: H

Stop



Item Name: Replacement Float Skidtube

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

110

0.00



HandFinish

HandFinishing

0.00

Hand Finishing

Memo

*****Do not apply LPS, see QC for more info*****

1-Spray inside tube of D3391-021/-023/-025 with LPS-3 as per Dwg D3391

A/R LPS-3 11/14

2-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with saddle holes for proper alignment. using 7/16" "T" Pins.

A/R ☐ Sikaflex-241/-291 11/12345

Expiry date: 10/09

3-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Coat bolts with LPS "procyon".

Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex.

A/R ☐ LPS Procyon 11/104251

A/R ☐ Sikaflex-241/-291 11/12345

Expiry date: 10/09

4-Remove "T" pins once sikaflex is dry.

5-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser.

=> 09-12-17



RTO

W/O: 52785		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
05.12.17	110	Acceptable to file inner saddle holes to allow assembly	HA	05.12.17	(X1)	CP 05.12.17 951042	S 05/12/17

Part No: D412-742-043 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 3

Item ID: D412-742-043

Accept

Revision ID: H

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Start Date: 14/10/2009 Start Qty: 1.00

Required Date: 02/11/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

Quality Control

0.00

130

Packaging

0.00



Packaging

Memo

Packaging

Identify and pack for shipping as per PPP D412-742-043

Location: _____

PPP Rev: _____

0.00

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

0.00

W 09.12.22

50/708 Ceq/14/11

09/12/22

Picklist Print

October 14, 2009 10:42:02 AM

Page 1

Work Order ID: 52785

Parent Item: D412-742-043RevH

Parent Item Name: Replacement Float Skidtube


Comments:

Start Date: 14/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C4A 		Purchased	No			110	Each	2,216.000	24.0000			
BOLT												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2216

112082

14

112314

40

112720

162

112724

500

112794

1000

112829

500

X24 11 04-12-17

AN3C6A

Purchased

No

110

Each

948.0000

12.0000

BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

948

111982

948

X12 11 04-12-17

Picklist Print

Page 2

October 14, 2009 10:42:02 AM

Work Order ID: 52785

Parent Item: D412-742-043RevH

Parent Item Name: Replacement Float Skidtube


Comments:

Start Date: 14/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C7A  BOLT		Purchased	No			110	Each	289.0000	8.0000			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 1113149 289
105906 21
107376 268

X 8 11 09-12-17

AN960C10L



washer

Purchased

No

110

Each

4,772.000

44.0000

Warehouse Loc Qty Loc Code
Location

OFFSHORE

FG 100
103585 100

Main Warehouse

ST 4672
112116 1009
112612 3663

NAS1149C0332R/1113288 X44 11 09-12-17

D3391-021RevH



Fwd Tube Assembly

Manufactured

No

110

Each

0.0000

1.0000

B52361

X1

11 09-12-17

Picklist Print

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Parent Item: D412-742-043RevH

Parent Item Name: Replacement Float Skidtube

Comments:

Start Date: 14/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3391-023RevH

Manufactured

No

110

Each

1.0000

1.0000



1353943

X1



24 09-12-17

Mid Tube Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1

40522

1

D3391-025RevH

Manufactured

No

110

Each

2.0000

1.0000



1352796

X1



24 09-12-17

Aft Tube Assembly

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

39129

1

48122

1

Picklist Print

Page 4

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Work Order ID: 52785



Parent Item: D412-742-043RevH



Parent Item Name: Replacement Float Skidtube

Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-1RevD		Manufactured	No			110	Each	29.0000	1.0000			
Wearshoe												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
33798	2	
Main Warehouse		
ST	27	
47531	1	
48163	4	
50270	1	
51676	21	

Y1 1109-12-17

Picklist Print

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Work Order ID: 52785



Parent Item: D412-742-043RevH



Parent Item Name: Replacement Float Skidtube



Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-3RevD		Manufactured	No			110	Each	20.0000	1.0000			
												
Wearshoe												

Warehouse
Location

Loc Qty

Loc Code

OFFSHORE

FG

2

33764

2

Main Warehouse

FP

11

(50113)

11

Main Warehouse

ST

7

46445

1

46652

3

50364

3

xi 09-12-17

Picklist Print

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Parent Item: D412-742-043RevH



Parent Item Name: Replacement Float Skidtube


Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3564-5RevD 		Manufactured	No			110	Each	30.0000	1.0000			
Wearshoe												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE	B53805	
FG	2	
34806	2	
Main Warehouse		
FP19	26	
51655	15	
51925	11	
Main Warehouse		
ST	2	
45824	1	
47433	1	

X1 M 04-12-12

Picklist Print

October 14, 2009 10:42:02 AM

Work Order ID: 52785

Parent Item: D412-742-043RevH

Parent Item Name: Replacement Float Skidtube

Comments:

Start Date: 14/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-1RevC		Manufactured	No			110	Each	11.0000	2.0000			

Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse	1354480	
FP	3	
51612	3	
Main Warehouse		
ST	8	
46349	1	
51218	1	
51259	3	
52313	3	

x1 52 09-12-17

Picklist Print

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Work Order ID: 52785



Parent Item: D412-742-043RevH



Parent Item Name: Replacement Float Skidtube

Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3566-5RevC		Manufactured	No			110	Each	25.0000	1.0000			

Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse	B33804	
FP	12	
51929	12	
Main Warehouse		
FP19	9	
51669	9	
Main Warehouse		
ST	4	
36113	1	
46186	1	
47318	1	
51260	1	

x1 jll 09-12-17

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RETURN TO

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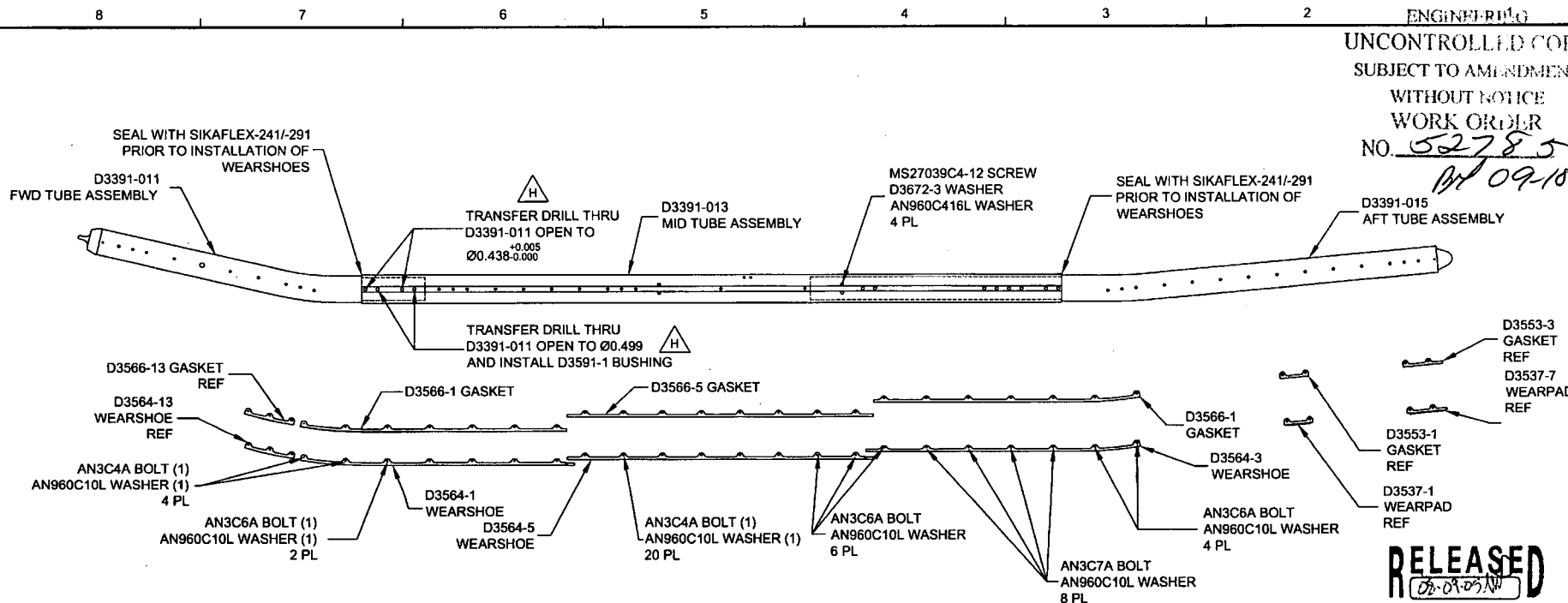
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 52785

09-10-14



D3391-041 ASSEMBLY

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

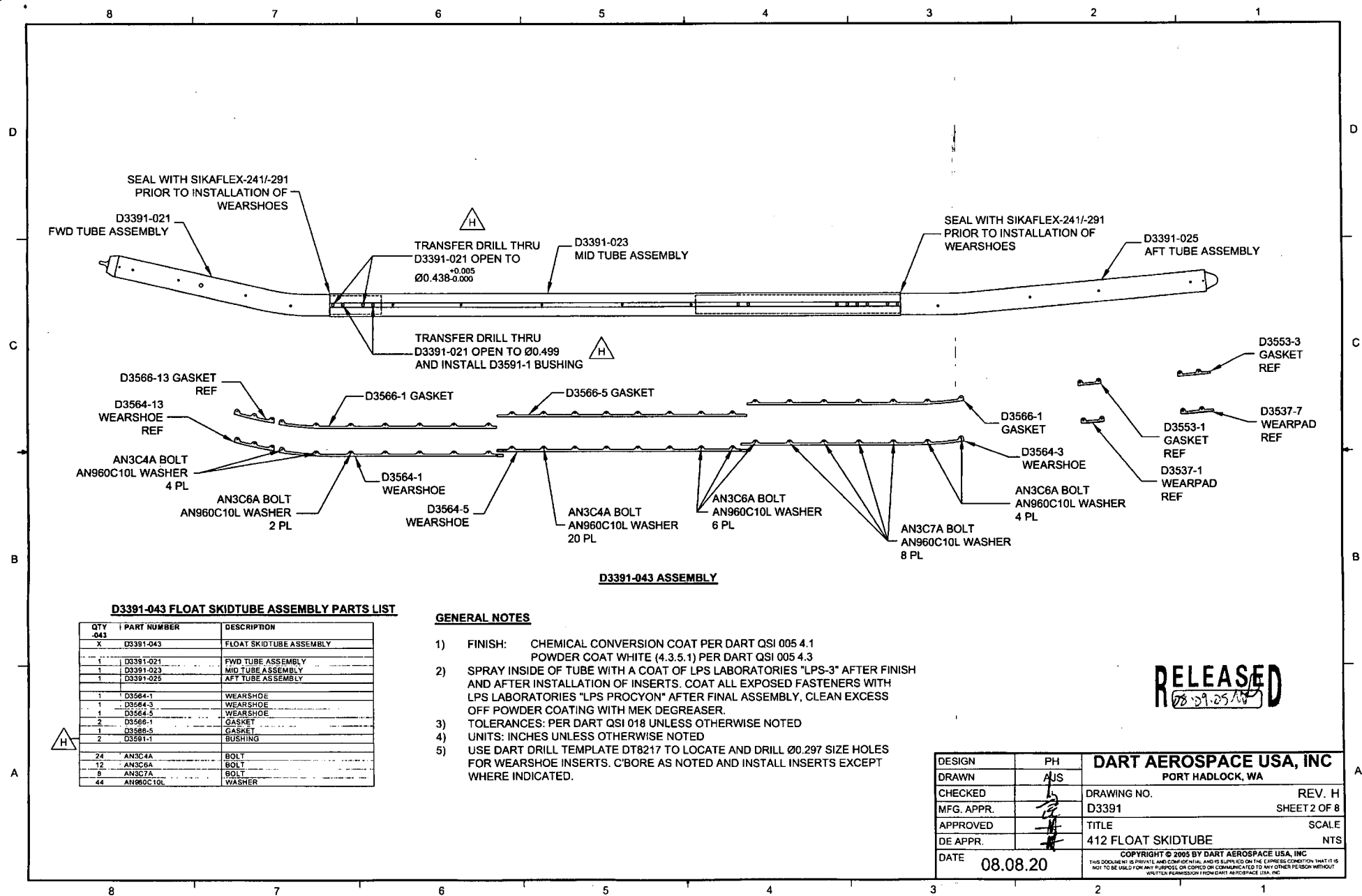
QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL 0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 0.438 DIM WAS 4 PL. ADDED 0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 0.438 DIM WAS 4 PL. ADDED 0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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W/O 52585



D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
9	AN3C7A	BOLT
44	AN960C10L	WASHER

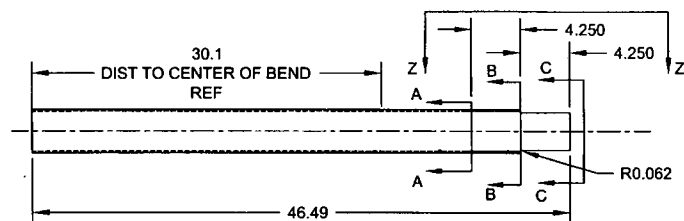
GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

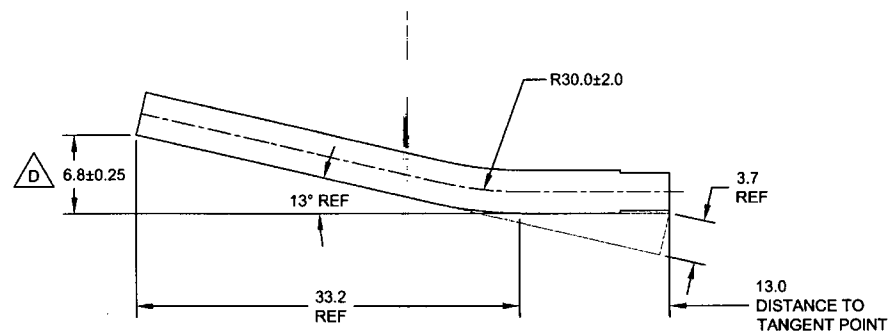
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08-09-25/10

DESIGN	PH	DART AEROSPACE USA, INC	
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CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 2 OF 8
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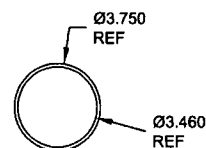
w/o 52785



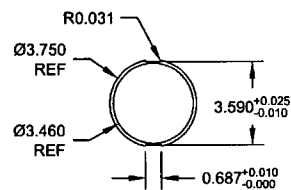
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



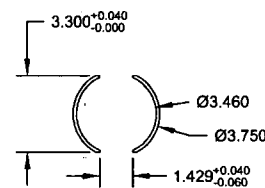
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



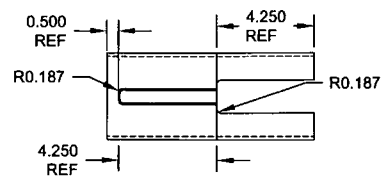
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

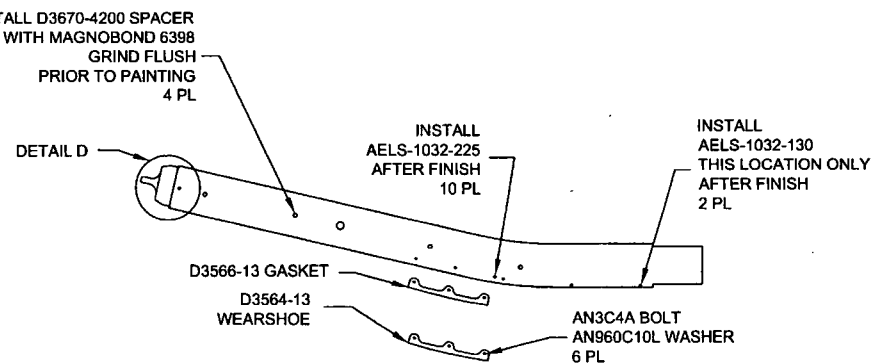
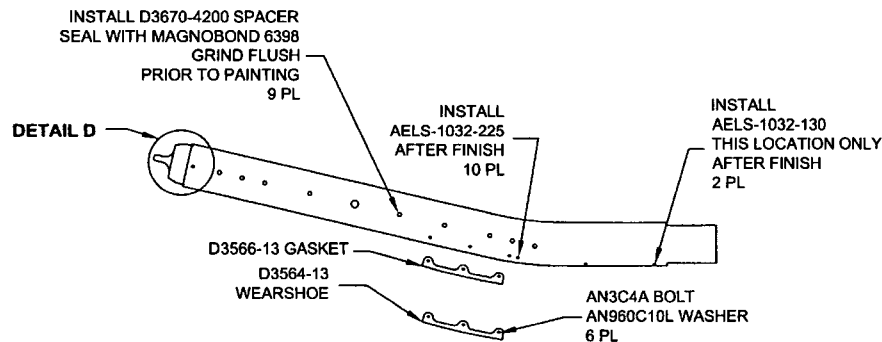
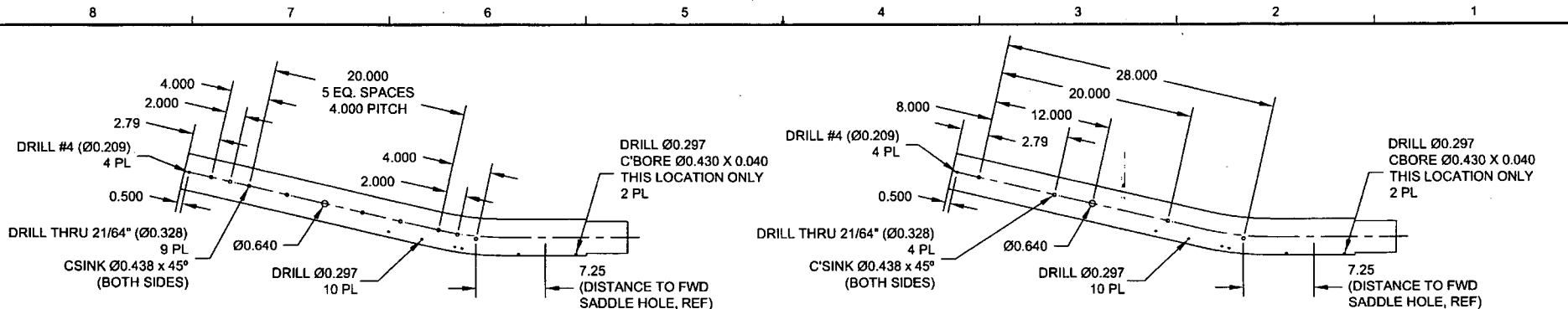


VIEW Z-Z
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08-05-11

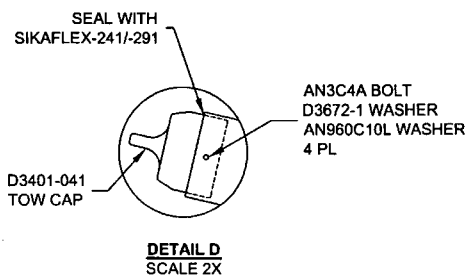
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DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 3 OF 8
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W/O 52785



D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

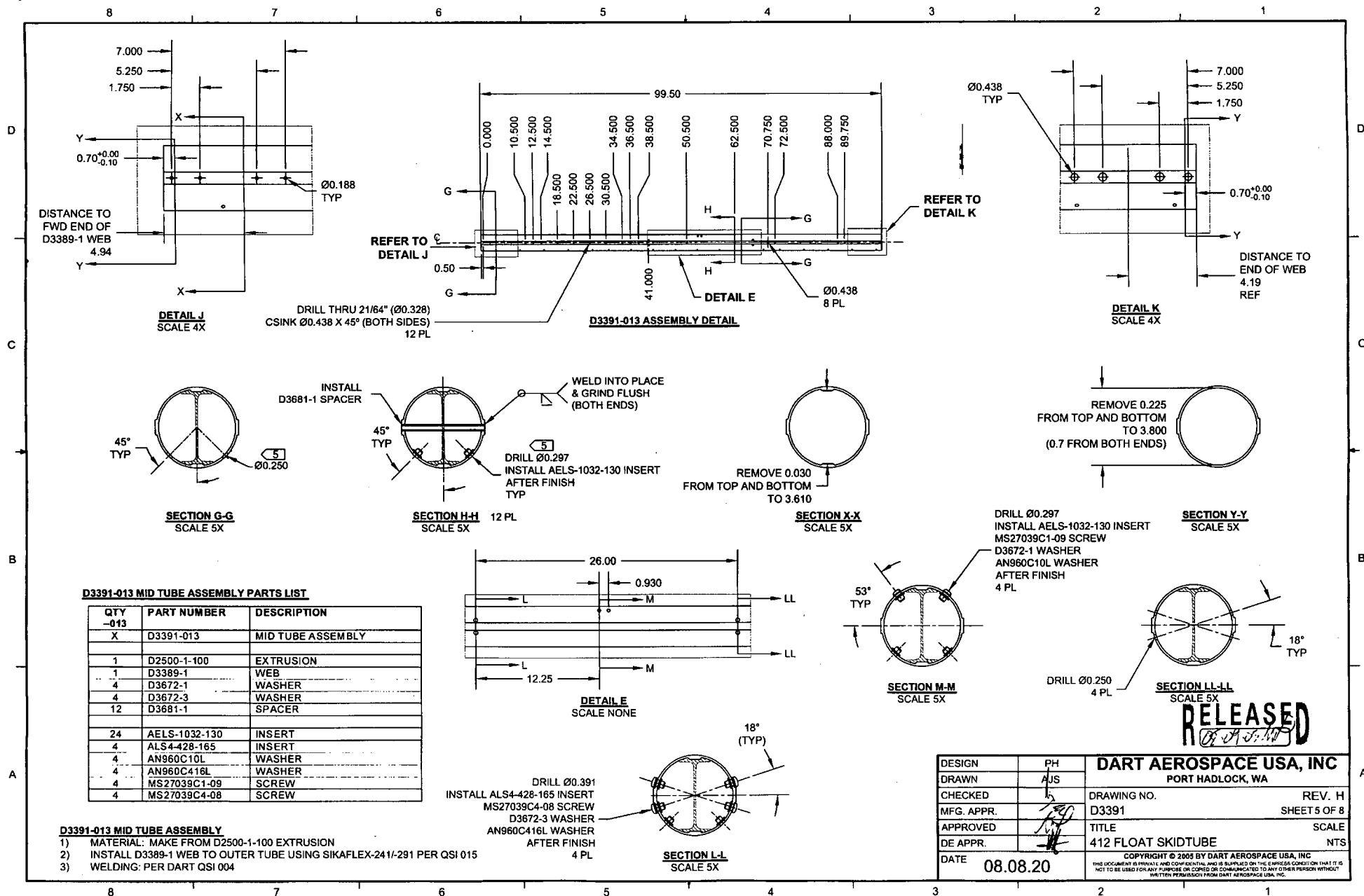
QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
9	4	D3670-4200	SPACER
4	4	D3672-1	WASHER
10	10	AN3C4A	BOLT
10	10	AN960C10L	WASHER
2	2	AELS-1032-130	INSERT
10	10	AELS-1032-225	INSERT



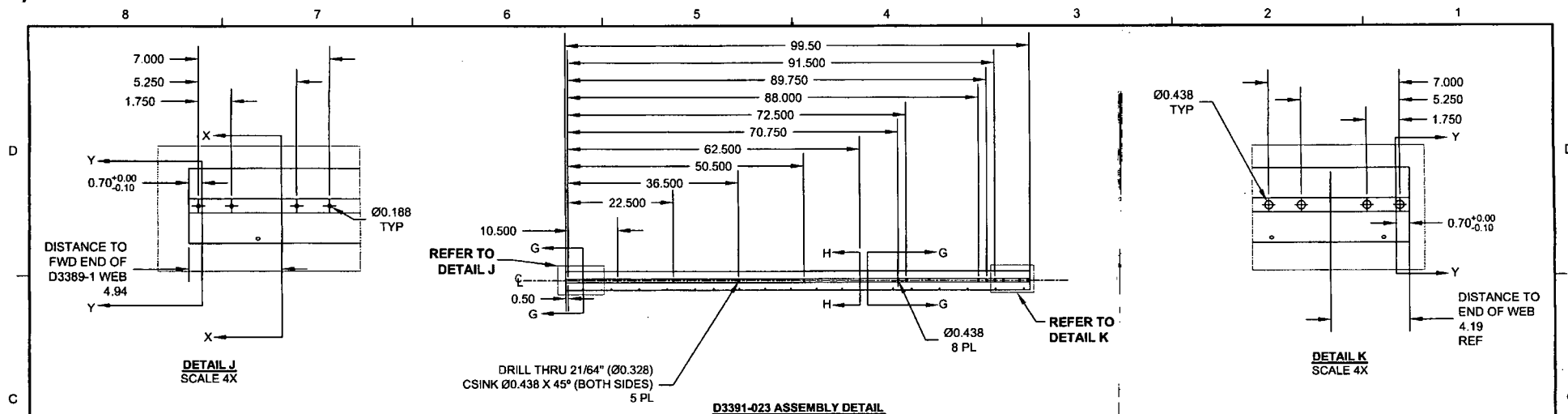
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DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 4 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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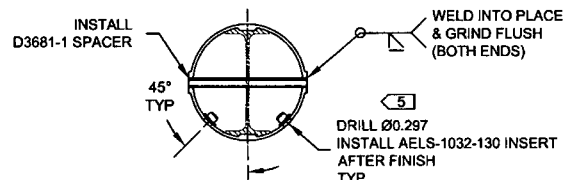
w/o 52785



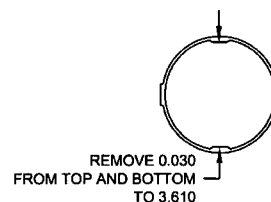
w/o 52785



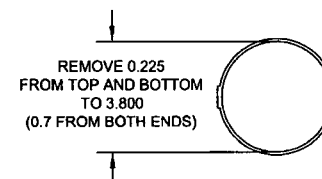
SECTION G-G
SCALE 5X



SECTION H-H
SCALE 5X



SECTION X-X
SCALE 5X



SECTION Y-Y
SCALE 5X

D3391-023 MID TUBE ASSEMBLY PARTS LIST

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

D3391-023 MID TUBE ASSEMBLY

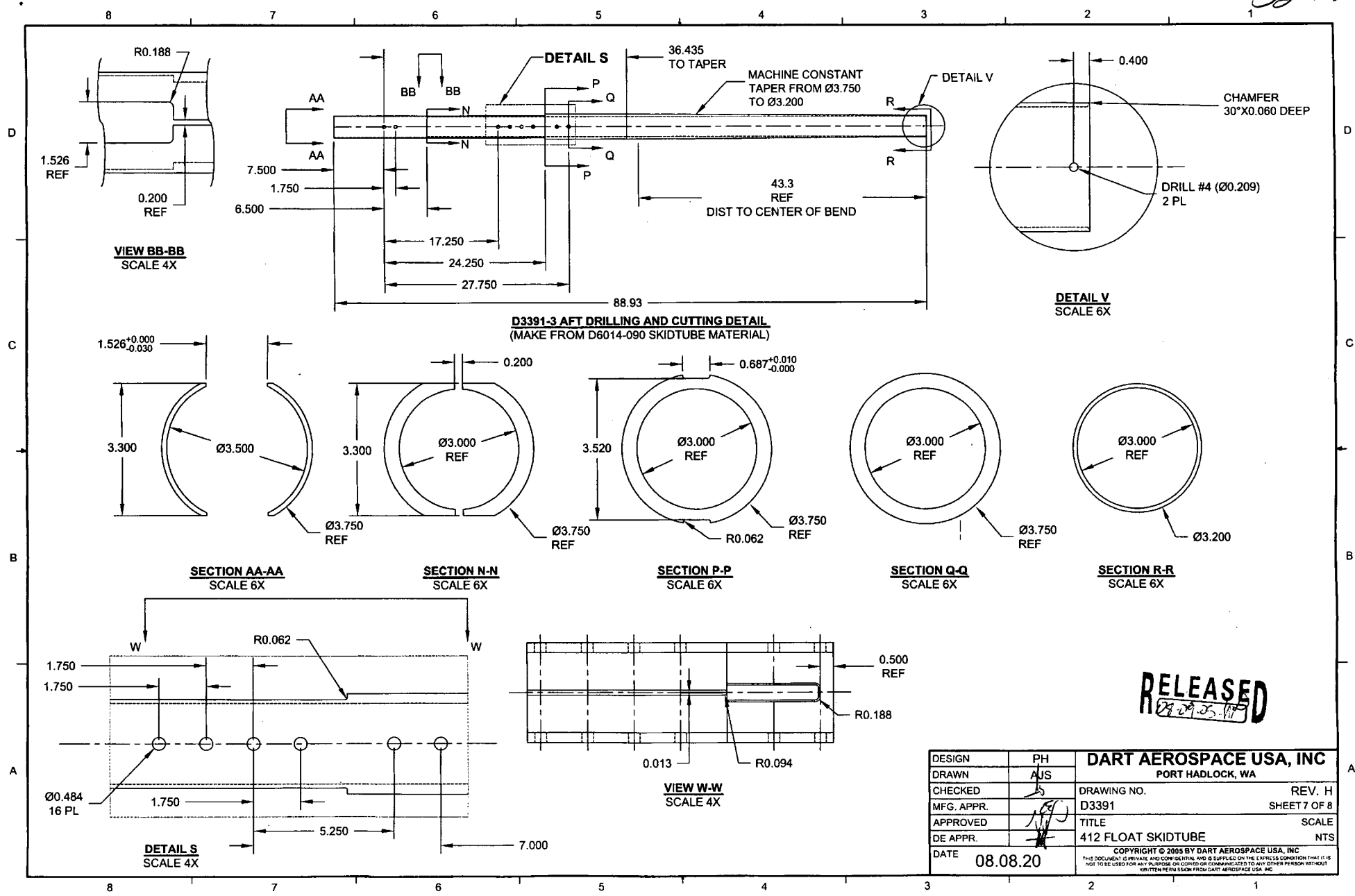
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
- 3) WELDING: PER DART QSI 004

RELEASED
08-29-85

DESIGN	PH	DART AEROSPACE USA, INC
DRAWN	AS	PORT HADLOCK, WA
CHECKED		DRAWING NO. REV. H
MFG. APPR.		D3391 SHEET 6 OF 8
APPROVED		TITLE SCALE
DE APPR.		412 FLOAT SKIDTUBE NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC

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52785



DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 7 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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